Certificate of Calibration & Traceability

23188

GAGE BLOCKS

Material: Steel No. of Blocks: 36pcs Standard: ASME B89.1.9-2002 Grade: 0 Set Serial No: 6211

Nominal size in inch	Deviation of central length from nominal size at 20℃	Id. NO	Nominal size in inch	Deviation of central length from nominal size at 20℃	Id. NO	Nominal size in inch	Deviation of central length from nominal size at 20℃	Id. NO
.050	+3	G4776	.102	0	B11243	.150	+2	G6337
.100	−1	F4277	.103	+1	B10922	.160	+1	G3480
.1001	+1	F2734	.104	−1	F5704	.170	+4	E5507
.1002	+4	G2990	.105	−1	G2387	.180	0	D0186
.1003	−1	C10544	.106	−1	F2244	.190	0	H1964
.1004	+2	G4354	.107	0	G1975	.200	0	G5521
.1005	+2	F0786	.108	+4	G3380	.300	+4	G1737
.1006	+2	D0356.	.109	+1	E7202	.400	−1	H0149
.1007	−2	E8532	.110	+3	E8119	.500	−1	H1118
.1008	−2	G1387	.120	−1	G4528	1.000	+3	H2261
.1009	−1	E6382	.130	+2	Z1091	2.000	+4	H3190
.101	−1	F5310	.140	+2	G6610	4.000	+5	G2902

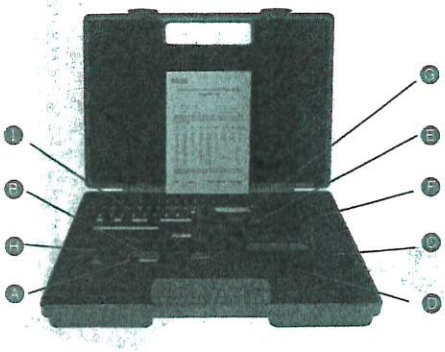
Master Gage Block Set Number: 21401.2 NIST Test No: 683/289870-17 Date: 2018-2-2

This calibration cetificate documents the traceability to national standard,which realize the unit of measurement according to the international system of units.
The uncertainty of the deviation for the central length l_c from nominal length l_n is U=2 μinch.
The value of the measurand lies within the assigned range of values with a probability of 95%.
The declaration of the measuring results ensured in compliance with ASME B89.1.9-2002. The length indications are valid fora reference temperature of 20℃ and for the measuring properties of the gague blocks shown during the calibration procedure.

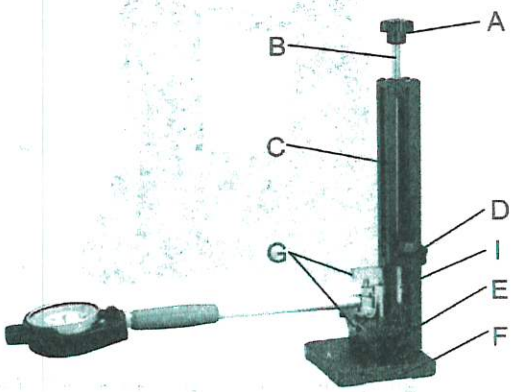
Date of Purchase: _____ DATE: 2018-8-17 QUALITY ASSURANCE: hangshao

BORE GAGE SETTING MASTER KIT

Please read through this owners manual carefully before using your new tool. Use your tool properly and only for its intended use.



A - Fine adjust knob
B - Pressure bar
C - Stand
D - Fastening knob
E - Supporting anvil
F - Base
G - Flat jaw (2pcs)
H - Supporting plate
I - Gage block
(36pcs/inch or 33pcs/mm)



Specifications

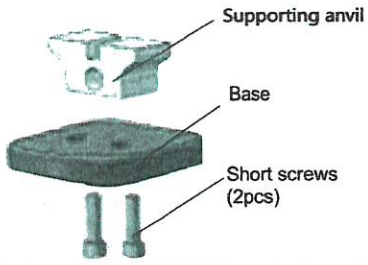
Setting Device

Quick-adjust holder for fast adjustment.

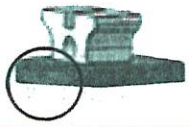
Order No.:	11-367-0
Internal Capacity:	0-6"
Gage Block Set:	36 pieces
Grade:	0
Tolerances:	±.00005"
Certificate of Calibration:	N.I.S.T

NOTE:
1. For best accuracy, remove all excess preservative from the gage blocks and flat jaws (G) before use.
2. Care should be taken to ensure the bore gage is kept as vertical as possible and not tilted to either side while rocking the bore gage, which could result in a false reading. It is also recom mended to sweep the bore at least one time after the initial setting to insure a good repeatable measurement.
3. It is recommended to keep a light coat of preservative on the gage blocks and base anvil while the gage is being stored to reduce the possibility of corrosion.

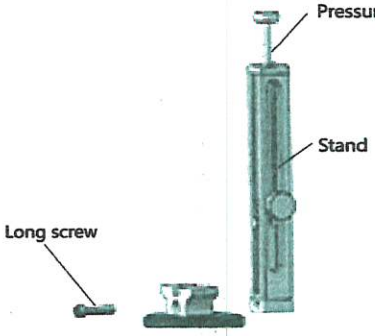
Assembly Instructions ▶



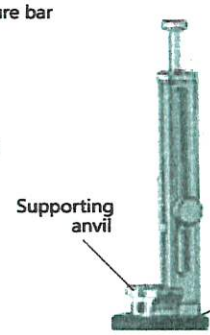
1. Connect the base and supporting anvil.



2.Please note this side is in the front.

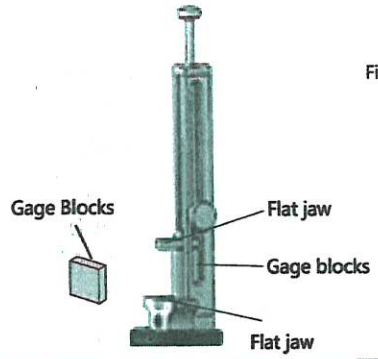


3. Connect the supporting anvil and stand.

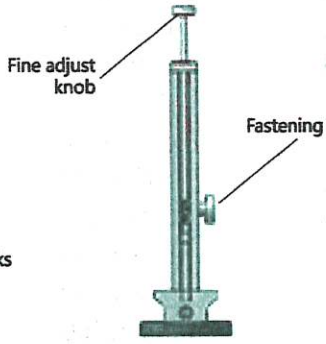


4. Complete assembling

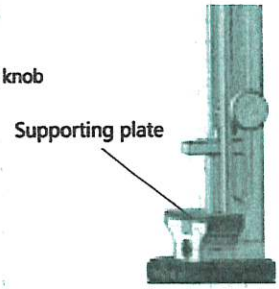
Operating Instructions ▶



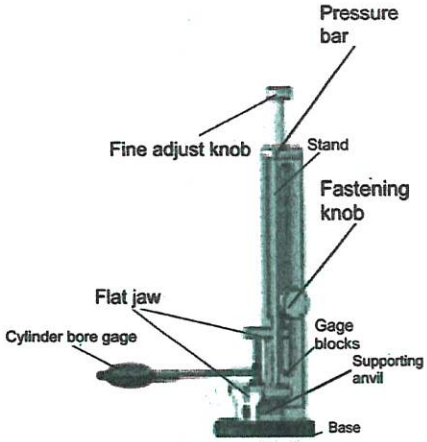
1.Load the flat jaws, the suitable gage blocks for the required dimension.



2.Push the Pressure bar to the bottom, then tighten the fastening knob. Tighten the fine adjust knob, hand tight to compress the flat jaws.

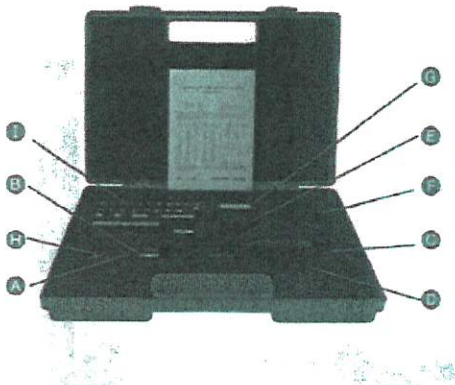


2.1 Load the supporting plate if the capacity of workpiece is over 1.4 inch or 35 mm.



3.Insert the cylinder bore gage into the bore gage setting master kit and while rocking the bore gage up and down, determine the reversal point of the bore gage, set the indication "0" at this reversal point.

Optional Spare Part List



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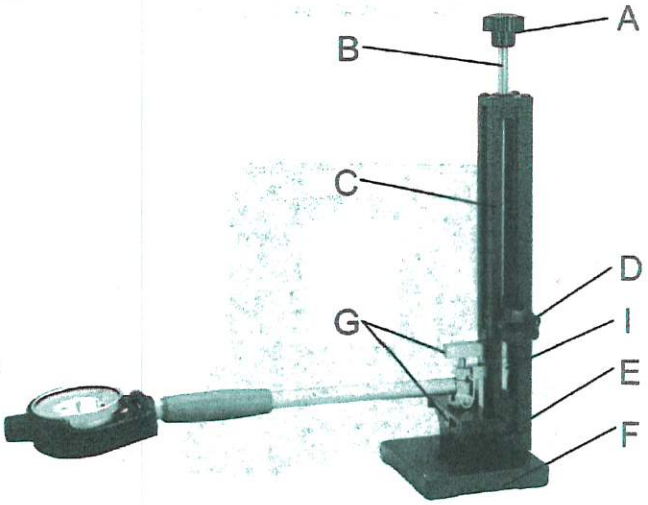

Main boby 612-9113 (A+B+C+D+E+F+G+H)

Individual Gage Blocks

Metric Rectangular Blocks		Inch Rectangular Blocks	
Number	Grade2 (ISO3650)	Number	Economy (NIST)
	mm		inch
632-2006	1.00	630-B305	0.050″
632-2101	1.01	630-B310	0.100″
632-2102	1.02	630-B101	0.101″
632-2103	1.03	630-B102	0.102″
632-2104	1.04	630-B103	0.103″
632-2105	1.05	630-B104	0.104″
632-2106	1.06	630-B105	0.105″
632-2107	1.07	630-B106	0.106″
632-2108	1.08	630-B107	0.107″
632-2109	1.09	630-B108	0.108″
632-2110	1.10	630-B109	0.109″
632-2120	1.20	630-B110	0.110″
632-2130	1.30	630-B120	0.120″
632-2140	1.40	630-B130	0.130″
632-2150	1.50	630-B140	0.140″
632-2160	1.60	630-B315	0.150″
632-2170	1.70	630-B316	0.160″
632-2180	1.80	630-B317	0.170″
632-2190	1.90	630-B318	0.180″
632-2220	2.00	630-B319	0.190″
632-2230	3.00	630-B320	0.200″
632-2240	4.00	630-B330	0.300″
632-2250	5.00	630-B340	0.400″
632-2260	6.00	630-B350	0.500″
632-2270	7.00	630-B100	1.000″
632-2280	8.00	630-B200	2.000″
632-2290	9.00	630-B400	4.000″
632-2300	10.00		
632-2400	20.00		
632-2530	30.00		
632-2550	50.00		